

08318



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT200078
Job Sheet 188863



Part No: RBT200078

Job Qty: 2 pcs

Part Name: Trunnion Bearing Removal & Install Work Aid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT200078 Rev. 2A IPP Rev. A 18.07.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Small Fab - 1	2 pcs	2/20/19		0.00	0.14	Small Fab - 1	AP 2019/02/26
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
110	QC 5	2 pcs	2/20/19		0.00	0.00	QC 5 - 10	Michel
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
130	Packaging 2 - 1 - Receive - B4B	2 pcs	2/20/19		0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	

Future Lead

Michel



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CANADA
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www.dartaerospace.com

Container No: S156622



Part: RBT200078

Job No: 188863

Serial No/Batch: S156622

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 02/26/19

DAS
40
9-89

DAS
9
9-89

19/03/04

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	MLC
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	

140 QC 21 - FG	2 pcs	2/20/19	0.00 0.00	QC 21 - FG - 21	QC 21 - FG - 70	21	MAR 04 2019
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Part Op 100 - (Small Fab) Assemble as per DWG.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) Bag and tag
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT200078-1	Trunnion Bolt (Hex Head Cap Screw)	① 2 pcs (1 ea)	100-Small Fab - 1	5147895
RBT200078-2	Trunnion Body	① 2 pcs (1 ea)	100-Small Fab - 1	5105226
RBT200078-3	Trunnion Spreader	① 2 pcs (1 ea)	100-Small Fab - 1	5105250

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RBT200078-1	2 /	3	0
	RBT200078-2	2 /	1	0
	RBT200078-3	2 /	1	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

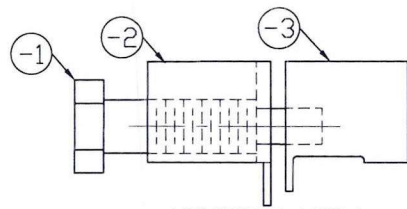


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

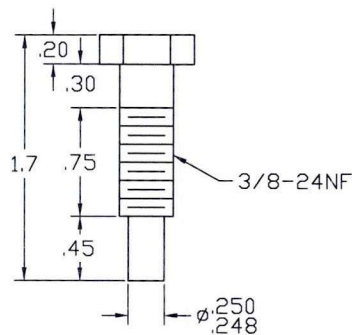
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



ASSEMBLY VIEW

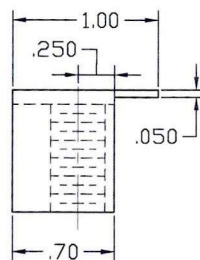
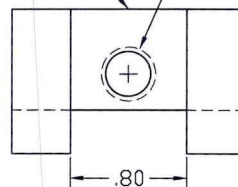


(-1)

BOLT

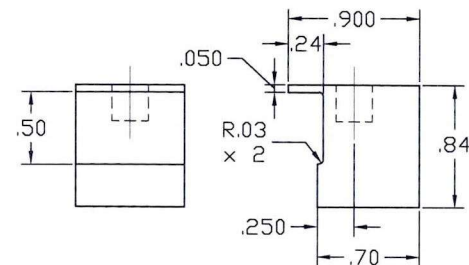
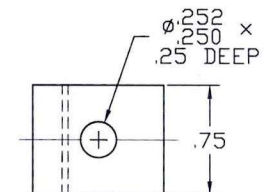
3/16 TEXT "RBT200078"

DRILL & TAP
3/8-24NF THRU



(-2)

BODY
HEAT TREAT 35-40 Rc



(-3)

SPREADER
HEAT TREAT 35-40 Rc

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188863 MJS
19-01-16

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED BOLT PIN FROM #.247, AND -3 HOLE FROM #.250; ALSO CHANGED P/N FROM T200078	8/16/06	WP	-
2	ADDED NEW TITLE BLOCK, BOM, & REVISIONS TABLE, AND ASSEMBLY VIEW. ALSO CHANGED MATERIAL DESCRIPTION FROM 1 in. WIDE.	3/6/08	WP	RW
2A	CH'D BOM LENGTH FROM 13/16 TO 7/8 -3 PER R.W.	12/17/10	RJC	RW

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS
	W/O	-1	1	HEX HEAD CAP SCREW	BLACK	3/8-24 x 1-3/4
		-2	1	BODY	4140	1 x 1-1/4 x 1-3/4
		-3	1	SPREADER	4140	1 x 1-1/4 x 7/8
ASSY						

RED BARN MACHINE	
TITLE TRUNNION BEARING REMOVAL AND INSTALLATION WORK AID	
DWG NO. RBT200078	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: COLE
DECIMALS .XXX ± .005	APPROVED D. Weil
.XX ± .01	HEAT TREAT LISTED BY PART
.X ± .1	FRACTIONS ± 1/32
	ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-15-01
SHEET 1	of 1